

Work Order ID 51522

August 25, 2009 1:35:02 PM



Page 1

Item ID: D2573

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Aft Out 205

Start Date: 8/28/09

Start Qty: 24.00



Cust Item ID:

Required Date: 9/18/09

Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

PLC2

Date: *09-8-25*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2573

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *51522* Double check by: *mmf* 11-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 13-
Machine Step No 3 per Folio FA051 and insp

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mmf 24 0
8/28/09/13

mmf 24 1
8/28/09/13

mmf 24 0
8/28/09/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2573 PAR #: N/A Fault Category: Mach. NCR: (Yes) No DQA: 1 Date: 09-11-06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 09-11-18

NCR: <u>51522</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/10/11</u>	<u>110</u>	<u>the dim. .315^{+0.00}_{-0.005} are .300</u> <u>part not placed/bottlenecked out.</u> <u>RC: operator error / LOA</u>	<u>CP</u> <u>09.10.16</u> <u>ju</u> <u>Q51042</u>	<u>SCRAP PART.</u> <u>0.300 = 10% REDUCTION</u> <u>IN SECTION STRENGTH</u> <u>Replace Qty 1 M <u>46412</u></u>	<u>gml</u> <u>09/10/16</u>	<u>DJP</u> <u>09/10/19</u>	<u>CP</u> <u>09.10.16</u> <u>ju</u> <u>Q51042</u>	<u>18/10/16</u>

NOTE: Date & initial all entries

Work Order ID 51522

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Item ID: D2573

Accept

Setup Start

Revision ID: E

Stop

Item Name: Saddle, Aft Out 205

Start Date: 8/28/09 Start Qty: 24.00

Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 24.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30AM

OVEN TEMPERATURE:

FINISH TIME:

320°F

M 112260

⇒ JH 09/10/20

(24) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51522

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Item ID: D2573

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle, Aft Out 205

Start Date: 8/28/09 Start Qty: 24.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00	BF 09-10-20			24			
QC Quality Control	Memo	0.00							
170 	Identify as per dwg & Stock Location: 434	0.00							
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

9/10/21 240

09/10/21 MF 09-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 51522

Parent Item: D2573RevE

Parent Item Name: Saddle, Aft Out 205



Start Date: 8/28/09

Required Date: 9/18/09

Comments:

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007RevB		Manufactured	No			100	Each	0.0000	24.0000			
												
Saddle Billet												

B46412

24x1 gnd 09/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

51522

DART AEROSPACE LTD	Work Order:	57326
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
				SCRAP					
A	0.438	0.443		.439	.439	.440	.440		
B	1.745	1.755		1.750	1.749	1.747	1.750		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.002	8.002		
F	0.490	0.510		.502	.502	.504	.504		
G	0.257	0.262		.260	.259	.259	.259		
H	0.375	0.380		.378	.377	.378	.378		
I	0.490	0.510		.504	.502	.503	.503		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.572	.570	.569	.570		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.365	1.375		1.369	1.369	1.369	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	4.119	4.129		4.123	4.124	4.124	4.124		
P	0.115	0.135		.124	.126	.124	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.121	.122	.124	.127		
T	0.178	0.198		.187	.187	.188	.188		
U	3.210	3.250		3.228	3.228	3.228	3.230		
V	0.230	0.250		.237	.240	.241	.241		
W	0.115	0.135		.121	.123	.131	.121		
X	0.308	0.313		.300	.310	.30	.310		
Y	0.760	0.765		.740	.760	.760	.760		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.635	.638	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.247	.248	.249		
AE	1.500	1.520		1.515	1.513	1.510	1.510		
AF	0.115	0.135		.127	.120	.125	.127		
AG	0.240	0.280		.278	.270	.280	.272		
AH	0.240	0.260		.248	.250	.251	.251		
AI	2.000	2.020		2.004	2.004	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 09/10/11	Date: 09/10/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

57522
32376

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Aft Outboard		Part Number: D2573	
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5x	6x	7x	8x		
A	0.438	0.443		.439	.439	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.000	8.002	8.005		
F	0.490	0.510		.502	.502	.503	.504		
G	0.257	0.262		.253	.253	.253	.253		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.504	.505	.503	.503		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		.568	.570	.576	.574		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.127	.127	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.254		
S	0.115	0.135		.125	.125	.126	.130		
T	0.178	0.198		.183	.183	.183	.183		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.243	.245	.242	.245		
W	0.115	0.135		.130	.126	.130	.135		
X	0.308	0.313		.310	.308	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.367	.362	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.618	.620	.638		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.513	1.508		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.253	.256	.254	.256		
AI	2.000	2.020		2.000	2.000	2.004	2.000		
AJ	0.023	0.043		.033	.030	.033	.033		
Accept/Reject									

Measured by: <u>SJS</u>	Audited by: <u>DTJ</u>
Date: <u>09/10/13</u>	Date: <u>09/10/13</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 57522 32346	
Description: Saddle, Aft Outboard		Part Number: D2573	
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9 4.	10 2	11 3	12 4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.006	8.002	8.003		
F	0.490	0.510		.506	.504	.502	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.371		
I	0.490	0.510		.504	.503	.502	.504		
J	1.174	1.184		1.177	1.178	1.178	1.178		
K	0.558	0.578		.571	.570	.571	.571		
L	1.174	1.184		1.177	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.124	.124	.125		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.253	.252	.251	.252		
S	0.115	0.135		.125	.125	.126	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.233	3.230	3.230	3.231		
V	0.230	0.250		.243	.242	.242	.241		
W	0.115	0.135		.130	.131	.131	.132		
X	0.308	0.313		.312	.312	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.366	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.621	.623	.623	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.509	1.510	1.510	1.509		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.280	.280	.280	.280		
AH	0.240	0.260		.254	.253	2.004 253	.252		
AI	2.000	2.020		2.000	2.001	2.004	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <i>RF</i>
Date: 09/10/13

Audited by: <i>DTJ</i>
Date: 09/10/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>RF</i>

57522

DART AEROSPACE LTD		Work Order: 32376	
Description: Saddle, Aft Outboard		Part Number: D2573	
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.438	0.443		.440	.440	.439	.440		
B	1.745	1.755		1.750	1.750	1.749	1.750		
C	3.495	3.505		3.500	3.500	3.499	3.500		
D	1.745	1.755		1.750	1.750	1.749	1.749		
E	7.990	8.010		8.000	8.003	8.003	8.002		
F	0.490	0.510		.504	.502	.504	.502		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.503	.504	.504	.503		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		.570	.570	.570	.569		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.127	.126	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.254	.251	.251		
S	0.115	0.135		.123	.124	.126	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.231	3.231	3.231		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.129	.130	.128	.132		
X	0.308	0.313		.310	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.367	.367	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.634	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.512	1.512	1.513		
AF	0.115	0.135		.135	.135	.135	.124		
AG	0.240	0.280		.280	.280	.280	.280		
AH	0.240	0.260		.252	.251	.250	.250		
AI	2.000	2.020		2.003	2.004	2.003	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>SP</i>	Audited by: <i>DT</i>
Date: 09/10/14	Date: 09/10/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 57522 32226
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	11	18 2	19	20		
A	0.438	0.443		.440	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.499	3.499		
D	1.745	1.755		1.750	1.750	1.749	1.749		
E	7.990	8.010		8.002	8.002	8.002	8.003		
F	0.490	0.510		.503	.502	.503	.503		
G	0.257	0.262		.258	.258	.259	.259		
H	0.375	0.380		.377	.377	.378	.377		
I	0.490	0.510		.503	.502	.503	.503		
J	1.174	1.184		1.177	1.177	1.178	1.177		
K	0.558	0.578		.567	.570	.569	.569		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.370	1.370	1.368	1.368		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	4.119	4.129		4.124	4.124	4.123	4.122		
P	0.115	0.135		.125	.125	.124	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.257	.252		
S	0.115	0.135		.128	.125	.122	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.228	3.228		
V	0.230	0.250		.241	.240	.240	.238		
W	0.115	0.135		.131	.130	.131	.130		
X	0.308	0.313		.311	.311	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.632	.631	.634		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.248	.246		
AE	1.500	1.520		1.510	1.510	1.511	1.514		
AF	0.115	0.135		.122	.123	.123	.126		
AG	0.240	0.280		.250	.250	.277	.273		
AH	0.240	0.260		.251	.257	.250	.248		
AI	2.000	2.020		2.001	2.000	2.001	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>JP</i>
Date: 09/10/14

Audited by: <i>JJP</i>
Date: 09/10/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

57522
~~52396~~

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Aft Outboard		Part Number: D2573	
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	#21	#22	#23	#24		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		8.002	8.002	8.002	8.003		
F	0.490	0.510		.503	.504	.503	.505		
G	0.257	0.262		.259	.259	.259	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.503	.502	.501	.501		
J	1.174	1.184		1.177	1.177	1.178	1.178		
K	0.558	0.578		.569	.568	.567	.567		
L	1.174	1.184		1.177	1.177	1.178	1.178		
M	1.365	1.375		1.367	1.368	1.368	1.368		
N	2.495	2.505		2.499	2.498	2.498	2.499		
O	4.119	4.129		4.121	4.121	4.125	4.124		
P	0.115	0.135		.125	.124	.123	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.251	.251		
S	0.115	0.135		.127	.122	.122	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.228	3.230	3.230		
V	0.230	0.250		.239	.240	.238	.239		
W	0.115	0.135		.130	.130	.121	.130		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.766	.760	.760	.760		
Z	0.352	0.372		.368	.367	.368	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.634	.623	.630	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.246	.246	.246		
AE	1.500	1.520		1.512	1.512	1.513	1.511		
AF	0.115	0.135		.125	.126	.125	.125		
AG	0.240	0.280		.275	.271	.275	.276		
AH	0.240	0.260		.250	.250	.248	.249		
AI	2.000	2.020		2.002	2.000	2.004	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

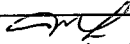
Measured by: <i>Grp</i>	Audited by: <i>DT</i>
Date: 09/10/15	Date: 09/16/15


Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order: 51522
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

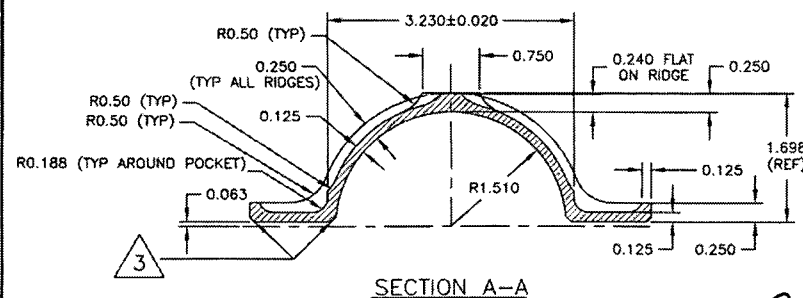
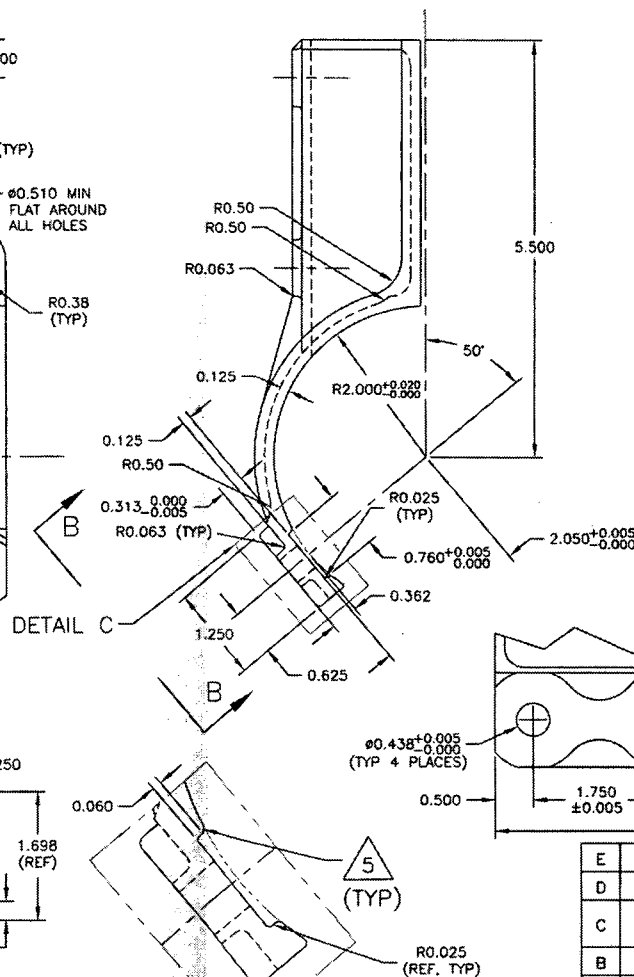
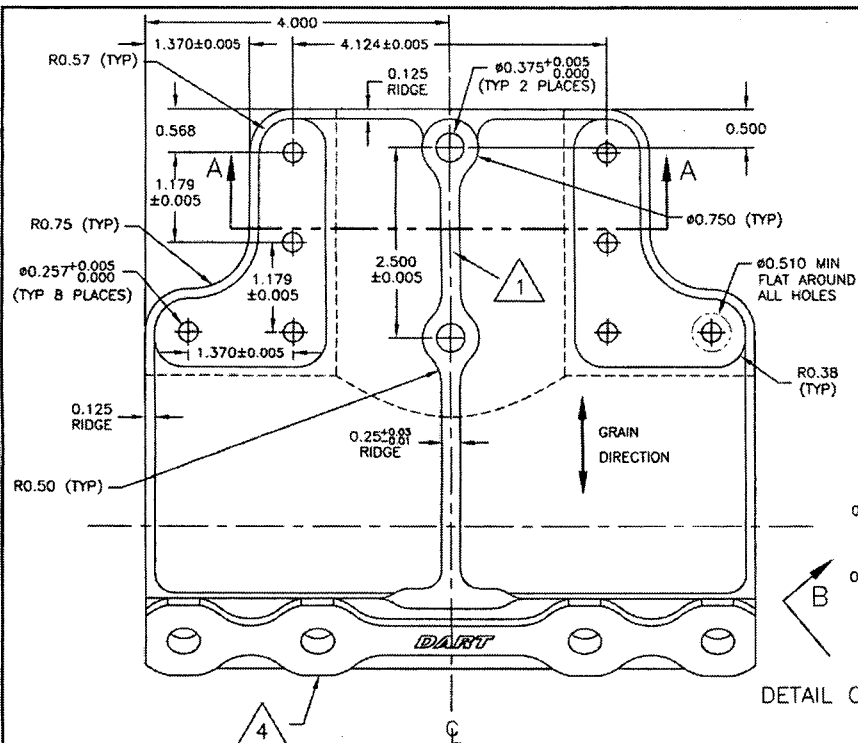
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.439					
B	1.745	1.755		1.749					
C	3.495	3.505		3.499					
D	1.745	1.755		1.749					
E	7.990	8.010		8.003					
F	0.490	0.510		.502					
G	0.257	0.262		.258					
H	0.375	0.380		.377					
I	0.490	0.510		.500					
J	1.174	1.184		1.178					
K	0.558	0.578		.565					
L	1.174	1.184		1.178					
M	1.365	1.375		1.369					
N	2.495	2.505		2.498					
O	4.119	4.129		4.122					
P	0.115	0.135		.124					
Q	0.115	0.135		.135					
R	0.240	0.260		.257					
S	0.115	0.135		.123					
T	0.178	0.198		.188					
U	3.210	3.250		3.230					
V	0.230	0.250		.240					
W	0.115	0.135		.130					
X	0.308	0.313		.312					
Y	0.760	0.765		.760					
Z	0.352	0.372		.367					
AA	0.470	0.530		.500					
AB	0.615	0.635		.626					
AC	0.053	0.073		.063					
AD	0.240	0.260		.246					
AE	1.500	1.520		1.572					
AF	0.115	0.135		.128					
AG	0.240	0.280		.272					
AH	0.240	0.260		.250					
AI	2.000	2.020		2.002					
AJ	0.023	0.043		.033					
Accept/Reject									

Measured by: 
Date: 09/10/14

Audited by: 
Date: 09/10/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM 	

05.12.06








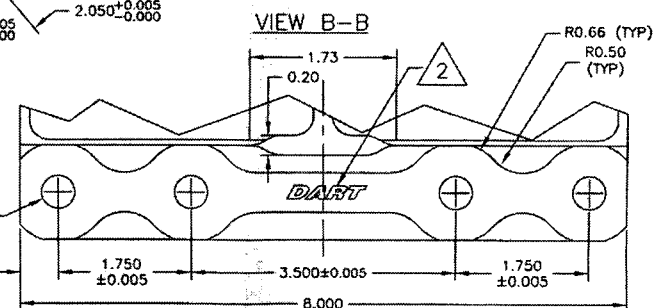
SECTION A-A




DETAIL C
SCALE 4:3

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DS	PH	
CHECKED 	APPROVED 	DRAWING NO. D2573
DATE 05.07.13		TITLE OUTER AFT SADDLE
		REV. SHEET 1 OF SCALE